

Work Order ID 128501***128501***

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Friday, January 16, 2015 2:50:06 PM

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 1/16/15 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/16/15 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 15-01-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4775	C								
110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00				<u>5</u>	<u>FF</u>		FEB 2 5 2015
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00				<u>5</u>	<u>FF</u>		FEB 2 5 2015
Small Fab	1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG								
	A/R PROSEAL BATCH: <u>1130986</u>								
	2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 Item Name: Strut Assembly
 Start Date: 1/16/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						<u>5</u>			
QC	Memo	0.00							
Quality Control									FEB 26 2015
140	Identify as per dwg & Stock Location: <u>SS4</u>	0.00							
140									
Packaging	Memo	0.00							5 FEB 28 2015 DAS 66 9-89
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									<u>MW</u> <u>1502-27</u>

Dis. 2.27

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 128501

128501

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM
13.09.26 AS PER REV.B DD VERF:JLM
AS PER REV.C DD VERF:JLM
IPP REV:C
IPP REV:D 14.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	20.0000	1	5			
D4775-1									**				
Strut Tube													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST514	20				5			
					127707	20							
D4777-1		Manufactured	No			110	Each	26.0000	1	5			
D4777-1									**				
Rod End Bearing													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST127	26				5			
					127488	26							
D4776-1		Manufactured	No			110	Each	40.0000	1	5			
D4776-1									**				
Basket Strut Clevis													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST126	40				5			
					127822	40							
D4776-5		Manufactured	No			110	Each	104.0000	4	20			
D4776-5									**				
Spacer													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST127	104				26			
					127743	104				7			

FEB 27 2015

FEB 27 2015

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 128501

128501

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 5.00

Required Qty: 5.00

AN3-10A Purchased No 110 Each 150.0000 2 10

AN3-10A

Bolt

**

FF

FEB 27 2015

Location	Loc Qty	Loc Code
GA 131320	16	
m127817	16	
ST338a	134	
m130466	134	

4
6

MS21042L3 Purchased No 110 Each 2,045.000 2 10

MS21042L3

Nut

**

FF

FEB 27 2015

Location	Loc Qty	Loc Code
FP001	447	
M130922	447	
ST305	1595	
M130799	31	
M131264	1564	
ST307	3	
123900	3	

10

MS21209-F615 Purchased No 110 Each 89.0000 1 5

MS21209-F615

Heli-Coil

**

FF

FEB 27 2015

Location	Loc Qty	Loc Code
GA	89	
m131270	89	

105

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